

Green

Date: Wednesday, 22/10/2008 11:47:14 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 42802		Part Number	: D2571		
Estimate Number	: 10530		Drawing Number	: D2571 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 22/10/2008 S.O. No. :		Drawing Revision	:		
Prsh Rev.	: NC		Material	:		
First Issue	: / / Type : MACHINED PARTS		Due Date	: 06/01/2009 Qty: 12 Um: Each		
Previous Run	: 35915					
Written By	:					
Checked & Approved By	: <u>JD 08.10.22</u>					
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>B41910</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>42802</u> Double check by: <u>ML</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Prod - MACT NCR: Yes No DQA: M Date: 08-11-13
 (D412-742-011/-013)
 (D205-634) QA: N/C Closed: J Date: 08/11/20

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/20	2.0	1 part scrap have a mark on the skid tube pattern. R.C. the face mill lifted the part, After the operator left for the evening. PROCESS.	08/10/20	SCRAP, TOO DEEP. Replace QTY 1 - same #	Qb 08/10/20	✓ 08/10/204	✓ 08/10/20	✓ 08/11/20

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

8808/11/06

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



(12)

7.0 POWDER COATING

POWDER COATING



M102316



(12X)

Comment: POWDER COATING

Powder **SANDTEX GREEN**
(Ref: 4.3.5.1) as per QSI 005 4.3

M-L

08/11/10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



EL



Comment: INSPECT POWDER COAT

08-11-10

(12X)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

L08/11/10 (12)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/10 (12)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	42802
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.503	.501	.490	.508		
G	0.257	0.262		.260	.259	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.498	.501	.498	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.567	.566	.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.874	3.874		
P	0.115	0.135		.131	.129	.129	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.254	.255	.255	.255		
S	0.115	0.135		.132	.127	.130	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		.242	.242	.243	.243		
W	0.115	0.135		.129	.126	.125	.126		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.366	.365	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.252	.251	.250	.250		
AE	1.375	1.395		1.390	1.390	1.390	1.390		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.253	.253	.253	.250		
AI	2.000	2.020		2.004	2.005	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 2nd / J.L
Date: 08/10/27 / 08/10/28

Audited by: SP / 08/11/08
Date: 08/11/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <u>SP</u> <u>JL</u>	

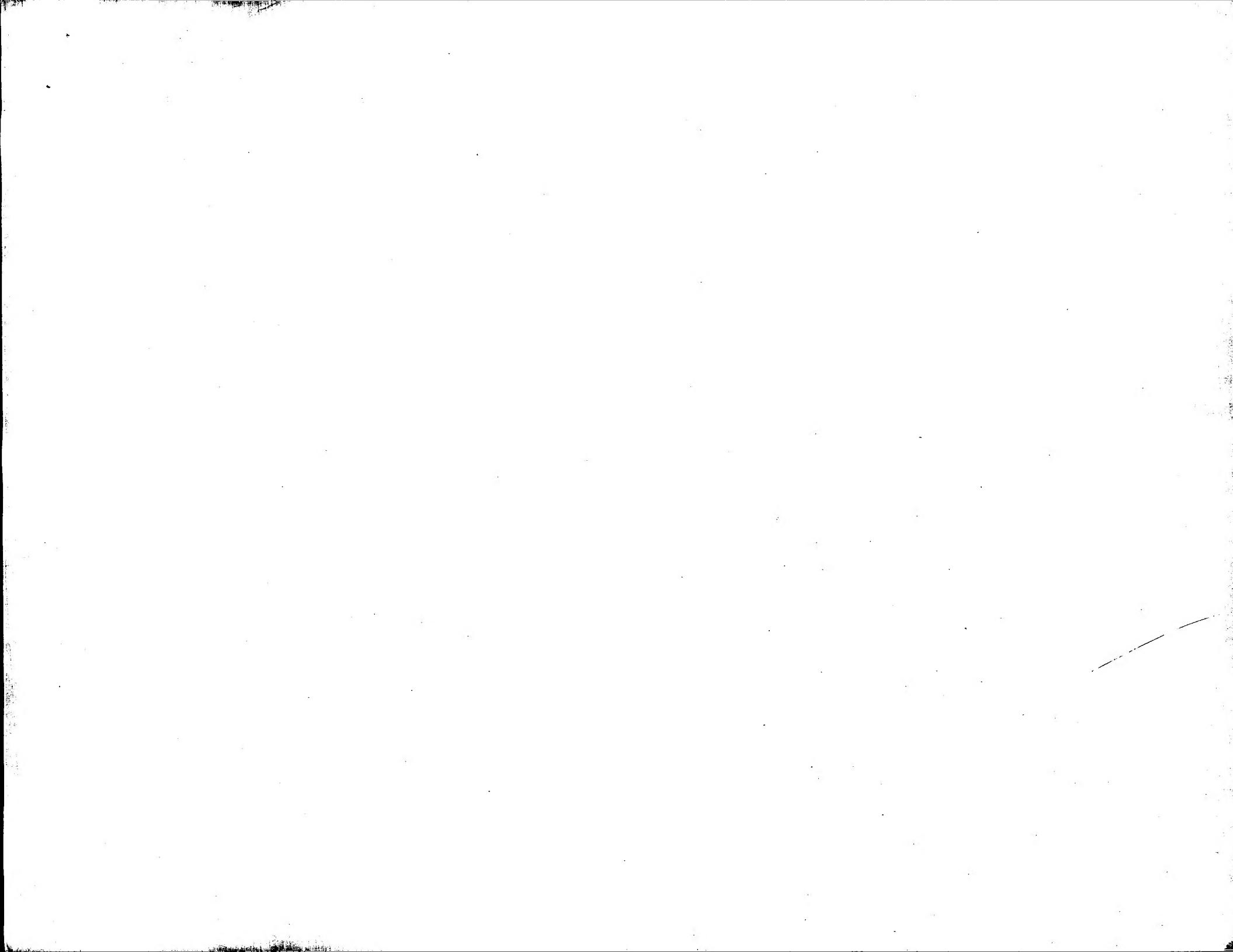
DART AEROSPACE LTD				Work Order: 42802			
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Inspection Dwg: D2571 Rev. E				Page 1 of 1			

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D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.000	8.001		
F	0.490	0.510		.500	.501	.502	.503		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.501	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.564	.564	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
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X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.368	.367	.365	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.627	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.248	.245		
AE	1.375	1.395		1.390	1.390	1.390	1.390		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.255	.255	.255	.258		
AH	0.240	0.260		.253	.253	.250	.248		
AI	2.000	2.020		2.005	2.005	2.004	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	51	Audited by:	88
Date:	08/10/06	Date:	08/11/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	2/11/06



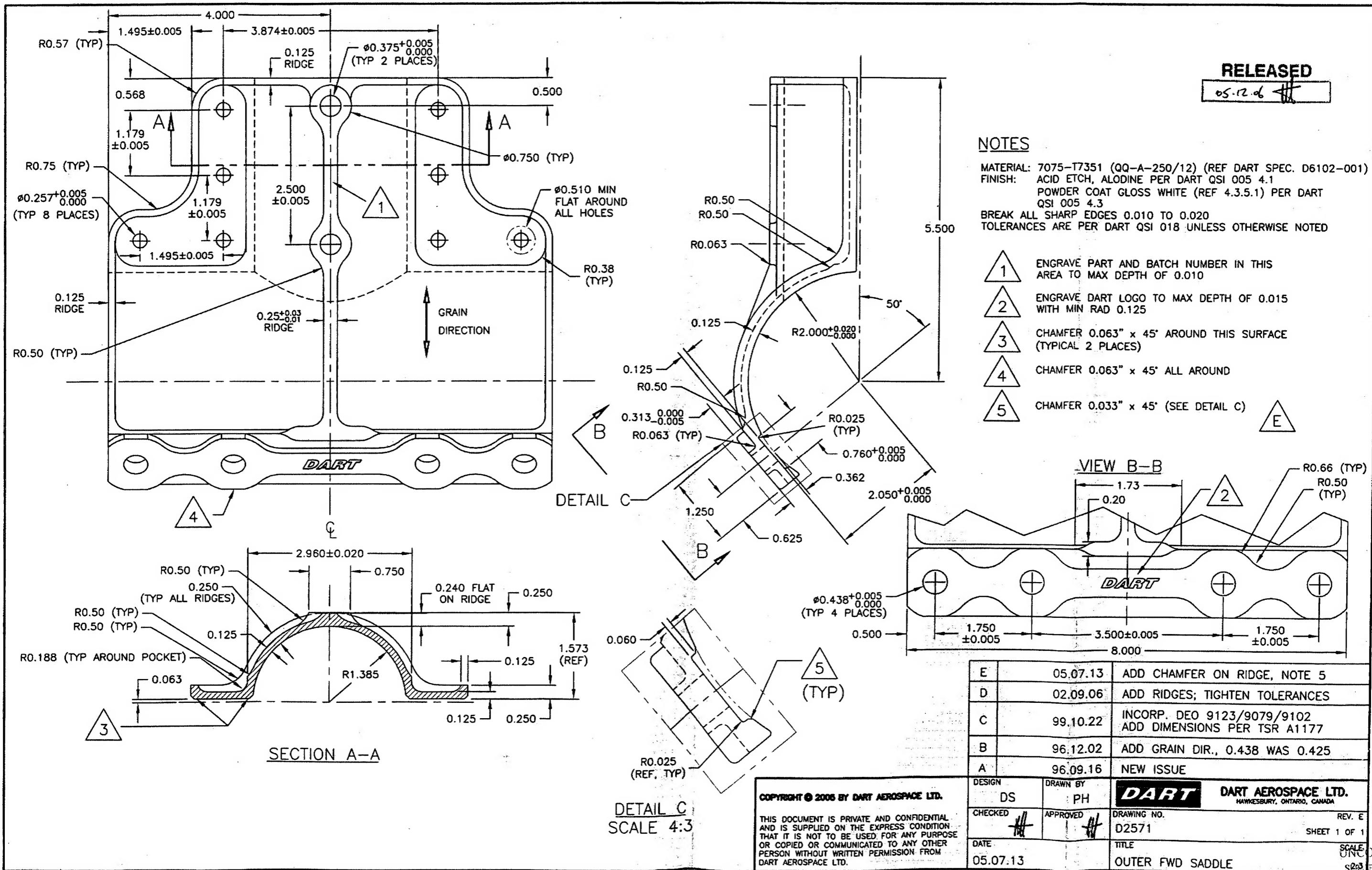
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D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.003	8.006	8.002		
F	0.490	0.510		.507	.503	.502	.502		
G	0.257	0.262		.260	.260	.259	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.496	.497	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.178		
K	0.558	0.578		.562	.564	.565	.567		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.493		
N	2.495	2.505		2.500	2.500	2.500	2.500		
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P	0.115	0.135		.131	.131	.131	.132		
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Accept/Reject									

Measured by:	cm	Audited by:	88
Date:	08/01/30	Date:	08/01/06

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